

# Work Order ID 84874

**\*84874\***

Page 1

May-29-12 7:17:39 AM

Item ID: D3684-045 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: LEG ASSEMBLY  
 Start Date: 5/29/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 5/30/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3684	Rev D								
100	Pick Kit	0.00							
<b>*100*</b>									
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
<b>*110*</b>									
Small.Fab	Memo	0.00							
Small Fab	1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as-per dwg D3684								
	2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684								
	***ensure holes AN3C bolts are clear of sealant***								
	Torque Fastners as per Dwg D3684								

M 122130

FF  
12-07-20

FF  
12-07-20

# Work Order ID 84874



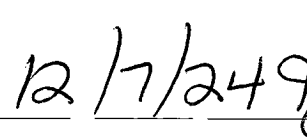
\*84874\*

Page 2

May-29-12 7:17:39 AM

Item ID: D3684-045 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: LEG ASSEMBLY  
 Start Date: 5/29/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/30/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
130 *130* Packaging Packaging	Identify as per dwg & Stock Location  Memo	0.00 0.00				1X			 12-7-23
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							 12-07-23

DAS  
16  
9-89  
12/6/12

# Picklist Print

May-29-12 7:17:39 AM

Page 1

Work Order ID: 84874  
Parent Item: D3684-045  
Parent Item Name: LEG ASSEMBLY

Start Date: 5/29/12

Required Date: 5/30/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM  
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC  
03-16 JLM VERIFIED BY:EC  
IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD  
IPP REV:C AS PER REV D 10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN3C12A Bolts		Purchased	No			110	Each	249.0000	2	2		① FF 12-07-20	
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Location	Loc Qty	Loc Code
GA	40	
120449	40	
ST351	209	
117514	4	
118112	5	
118451	22	
119510	1	
120423	77	
121584	50	
121689	50	

D3688-5 STUD		Manufactured	No			110	Each	3.0000	1	1		① FF 12-07-20	
-----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	---------------	--

Location	Loc Qty	Loc Code
GA	3	
79308	3	

D3689-1 SLEEVE		Manufactured	No			110	Each	1.0000	1	1		① FF 12-07-20	
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Location	Loc Qty	Loc Code
ST061	1	
72117	1	

D3691-1 STUD		Manufactured	No			110	Each	2.0000	1	1		① FF 12-07-20	
-----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	---------------	--

Location	Loc Qty	Loc Code
GA	2	
78909	1	
80363	1	

# Picklist Print

May-29-12 7:17:39 AM

Page 2

Work Order ID: 84874

Parent Item: D3684-045

Parent Item Name: LEG ASSEMBLY

Start Date: 5/29/12

Required Date: 5/30/12

Start Qty: 1.00

Required Qty: 1.00

D3692-1  
SPACER

Manufactured No

110 Each 437.0000

4

4

① FF 12-07-20

Location	Loc Qty	Loc Code
ST061	437	
51467	16	
<u>80364</u>	21	
81729	100	
81961	200	
83257	100	

4

D3693-1  
Rod End Bearing

Manufactured No

110 Each 21.0000

1

1

① FF 12-07-20

Location	Loc Qty	Loc Code
GA <u>83612</u>	21	
80275	1	
81738	20	

1

MS21043-3  
Nut

Purchased No

110 Each 1,655.0000

2

2

① FF 12-07-20

Location	Loc Qty	Loc Code
FG	72	
103691	72	
GA	30	
120693	30	
ST301	1553	
118077	2	
118614	51	
118686	30	
119758	20	
<u>121255</u>	450	
121708	1000	

2

# Picklist Print

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Page 3

Work Order ID: 84874

Parent Item: D3684-045

Parent Item Name: LEG ASSEMBLY

Start Date: 5/29/12

Required Date: 5/30/12

Start Qty: 1.00

Required Qty: 1.00

NAS509-12C

Purchased

No

110

Each

114.0000

1

1

① FF 12-07-20

Nuts

## Location

## Loc Qty

## Loc Code

ST279

114

120422

9

121162

20

121274

25

121556

10

121827

50

NAS509L12C

Purchased

No

110

Each

64.0000

1

1

① FF 12-07-20

Nuts

## Location

## Loc Qty

## Loc Code

279

10

121652

10

ST279

54

112314

3

112828

1

120498

10

121349

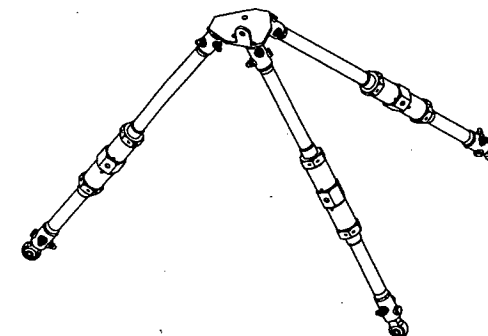
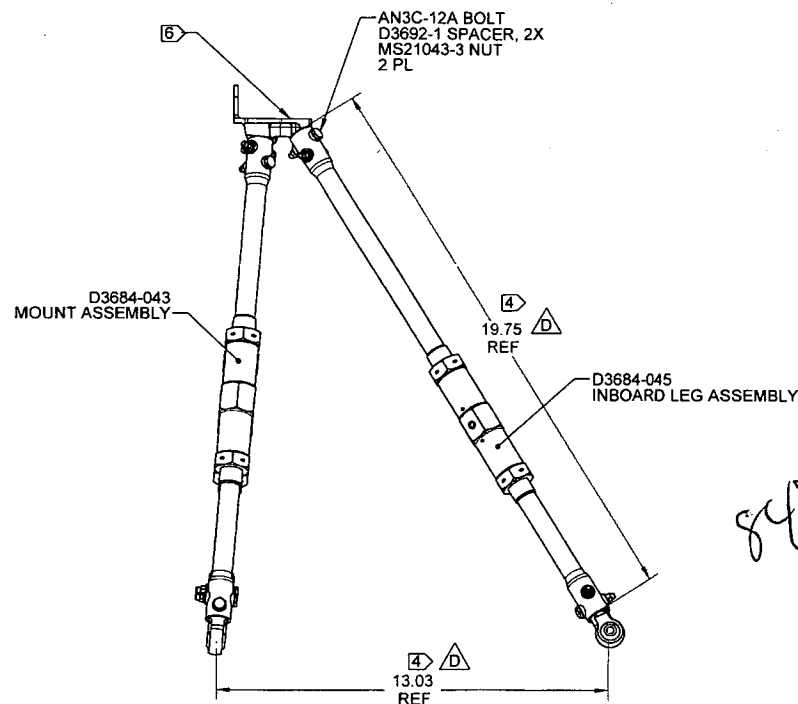
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May-29-12 7:17:39 AM

Shop Packet Print

Page 3

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3684-041	TRIPOD MOUNT ASSEMBLY
2	1	D3684-043	MOUNT ASSEMBLY
3	1	D3684-045	INBOARD LEG ASSEMBLY
4	4	D3692-1	SPACER
5	2	AN3C-12A	BOLT
6	2	MS21043-3	NUT



**D3684-041 TRIPOD MOUNT ASSY** ⑦

**NOTES:**

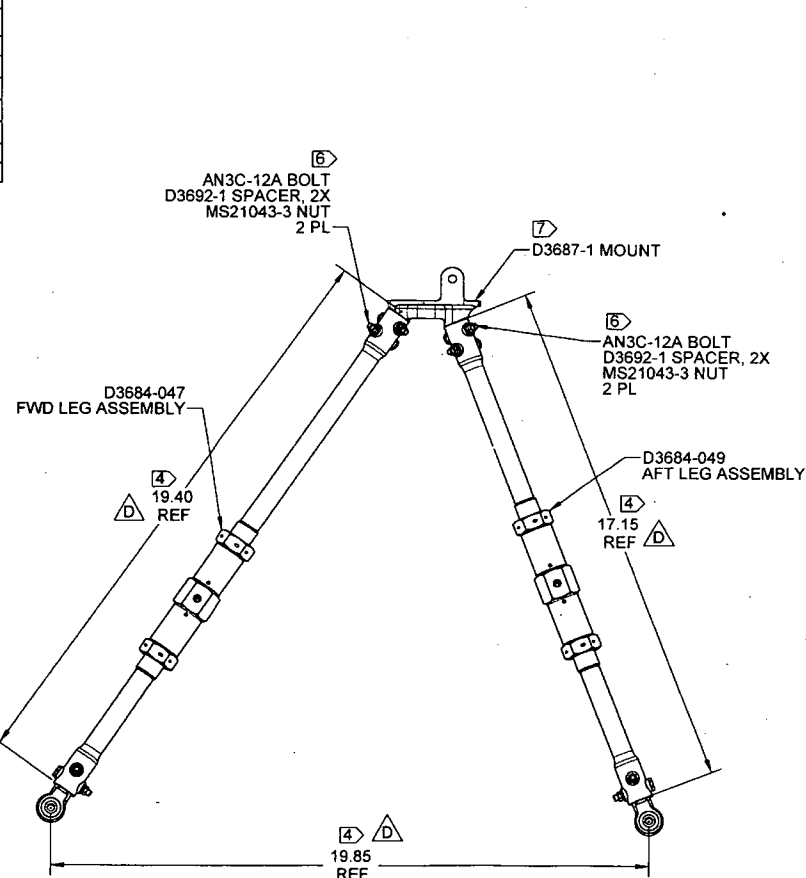
- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3/-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 9.9 lbs
- 6) ASSEMBLE D3684-045 WITH D3684-043 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT
- 7) ASSEMBLY SHOWN FOR REF ONLY, -041 IS PACKAGED UNASSEMBLED

D	13.03 WAS 13.10 (ZN B5-1); 19.75 WAS 19.87 (ZN C4-1); 19.40 WAS 19.52 (ZN C6-2); 17.15 WAS 17.27 (ZN C4-2); 19.85 WAS 20.24 (ZN B5-2); 20.96 WAS 21.09 (ZN C5-3); 20.62 WAS 20.74 (ZN C5-4); 18.37 WAS 18.49 (ZN C6-5)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, D6-1, A8-2, D4-2, A8-3, B4-3, A8-4, B4-4, A8-5, B5-5); ASSEMBLY NOW SHOWN FOR REF ONLY (ZN A8-1, A4-1)	RF	08.12.15
B	19.52 WAS 19.50 (ZN C6-2); 9.20 WAS 9.70 (ZN C6-2); 20.74 WAS 21.24 (ZN C5-4); 6.95 WAS 6.98 (ZND5-5); MODIFIED PER PROTOTYPE INSTALLATION; REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	#	DRAWING NO.	REV. D
MFG. APPR.	#	<b>D3684</b>	SHEET 1 OF 5
APPROVED	#	TITLE	SCALE
DE APPR.	#	<b>TRIPOD MOUNT ASSY</b>	NTS
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**RELEASED**  
2010-03-15  
MAD

84874

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D3684-043	MOUNT ASSEMBLY
2	1	D3687-1	MOUNT
3	1	D3684-047	FWD LEG ASSY
4	1	D3684-049	AFT LEG ASSY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



**D3684-043 MOUNT ASSEMBLY**

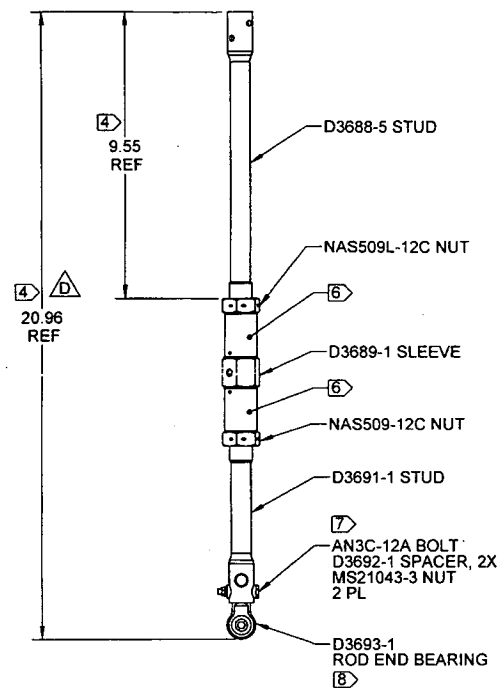
**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
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MFG. APPR.		D3684	SHEET 2 OF 5
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RELEASE  
2010-03-15

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



**D3684-045 INBOARD LEG ASSEMBLY**

**RELEASED**  
2010-03-15

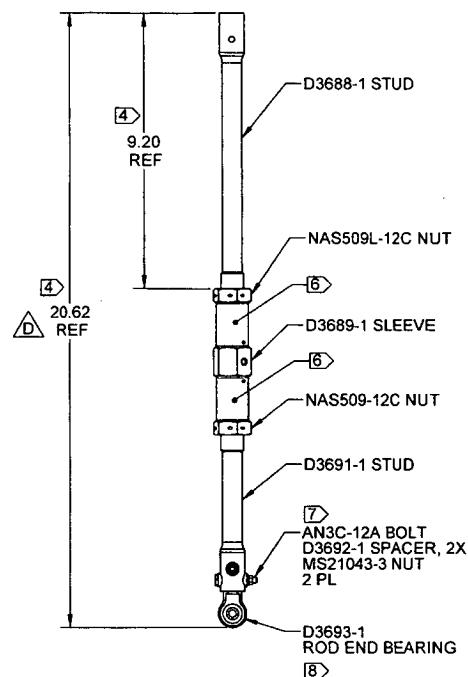
**NOTES:**

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- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

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DE APPR.		<b>TRIPOD MOUNT ASSY</b>	NTS
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



**D3684-047 FWD LEG ASSEMBLY**

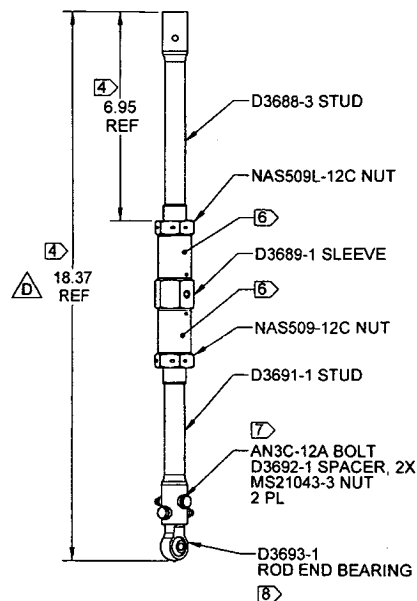
**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.09 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

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**RELEASED**  
2010-03-15

ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



**D3684-049 AFT LEG ASSEMBLY**

**RELEASED**  
2010-03-15

**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.86 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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